

Date: Tuesday, 19/08/2008 4:07:29 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 20 DEGREE COVER PLATE
 Job Number : 41513-1
 Estimate Number : 13384
 P.O. Number :
 This Issue : 19/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 40094
 Written By :
 Checked & Approved By : JUL 08.8.20
 Comment : Est Rev:A 08-06-19 new issue DD verified by:ec

Part Number : PB674300173
 Drawing Number : B6743001 PAGE26
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 18/09/2008 Qty: 30 Um: Ea

split 10

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



IB 8-9-8



Comment: Qty.: 1.0692 sf(s)/Unit Total: 32.0765 sf(s)
 6061-T6 Sheet 0.032" *18147*
 batch:

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001
 Dwg Rev: B1
 Prog Rev: B1
 ****grain direction along 6.950" ****
 2-Deburr if necessary

IB 8-9-8

IB 8-9-8

(31)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-9-8



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



See 08/09/08 (x31) water

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg B67-43001

See 08/09/08

Process Sheet

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Drawing Name: 20 DEGREE COVER PLATE

Job Number: 41513

Part Number: PB674300173

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/15 (x31) count

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1- weld as per dwg B67-4300

Ph 08.09.16 (10)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-grind weld flush

Ph 08.09.17 (10)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 08.09.17 10

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/17 (10)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-P 08/09/18 (10x)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M102316

START TIME:

1:45pm

OVEN TEMPERATURE:

320°C

FINISH TIME:

2:15pm

9/1 08.09.18 (x10)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ph 08/09/18 (10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 20 DEGREE COVER PLATE

Job Number: 41513

Part Number: PB674300173

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

02/08/09/19

(10)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

08/10/06

(10)

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/10/07 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST510

08/10/07

(10)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

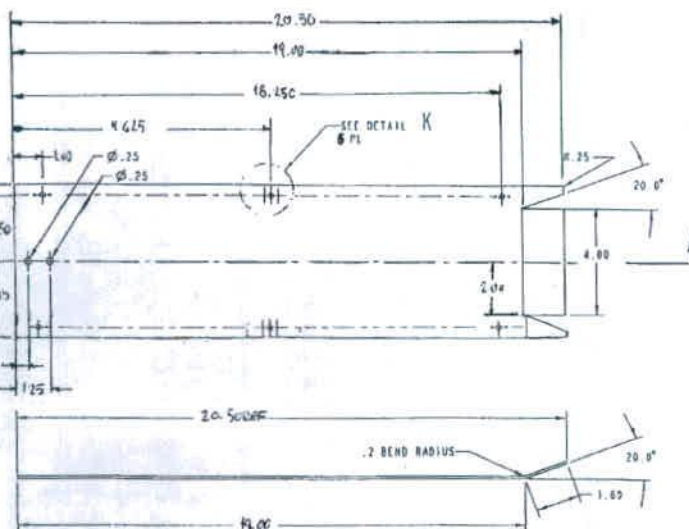
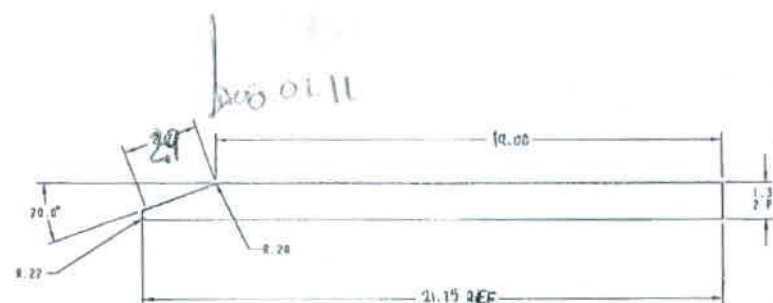
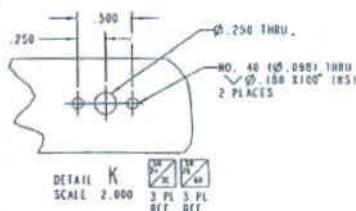
08/10/08

Job Completion



mf 08-10-07

RELEASED
46 of 20



② -159 SUPPORT PLATE
MATERIAL: .032 THK. 6061-T6, QQ-A-250/11
SCALE 0.500

PART IS SYMMETRICAL ABOUT CENTER LINE

② -73 20 DEGREE COVER PLATE
MATERIAL: .032 THK. 6061-T6, QQ-A-250/11
SCALE 0.500

PREMIER AVIATION, INC.
8800 Aviation Parkway, Grand Prairie, Texas 75050
D105UV8 B57-43001
REV. 8/

ORIGINAL

NO 415
UNCONTROLLED COPY
RETURN TO
SHOP COPY
RETURN TO
DIRECTOR

ART AEROSPACE LTD

Work Order:	41513
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Description: 20° COVER PLATE

Part Number:	PB6743001-73
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Inspection Dwg: _____, Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	LB
Date:	8-9-8

Audited by:	C
Date:	08/09/08

Prototype Approval:	<i>[Signature]</i>
Date:	<i>[Signature]</i>

Rev	Date	Change	Date:	1/1
A		New Issue	Revised by	Approved
			KJ/JLM	

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : CATULSAF1123HAW
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Packing Slip No.

30330

Ship Date

3-Oct-08

Ship To:

Dart Aerospace
1270 Aberdeen Street
Main Finished Goods Location
Buyer=Chantal Lavoie 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order No.	Order Date	Customer No.	Sales Rep.	Release Note No.
21999	19-Sep-08	CDART100	Barney Bangs	R92- 30330
Customer PO Number	Ship Via	PPD/COL	Qty Backordered	
PO00007202	Pick-Up			
Item No.	Qty	UOM	Qty Shipped/Returned	Description
8421-105	10	EA	10	
Dart Blade Fold Kit - Pad #6/ Drawing No: (Ref B67-43001-73 Rev B1) DWG Rev: A Lot No: BATCH0000000003 Qty: 10				
8421-106	10	EA	10	
Dart Blade Fold Kit - Pad #7/ Drawing No: (Ref B67-43001-69 Rev B1) DWG Rev: A Lot No: BATCH0000000003 Qty: 10				
8421-102	12	EA	12	
Dart Blade Fold Kit - Pad #3/ Drawing No: (Ref B67-43001-85 Rev B1) DWG Rev: NR Lot No: BATCH0000000004 Qty: 12				
8421-101	20	EA	20	
Dart Blade Fold Kit - Pad #2/ Drawing No: (Ref B67-43001-83 Rev B1) DWG Rev: NR Lot No: BATCH0000000003 Qty: 20				

Barney Bangs

RELEASE NOTE

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : CATULSAF1123HAW
www.tulmar.com
email: info@tulmar.com

Release Note No.

R92-30330

Ship Date

3-Oct-08

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Ship To:

Dart Aerospace
1270 Aberdeen Street
Main Finished Goods Location
Buyer=Chantal Lavoie 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order No. 21999
Order Date 19-Sep-08

Customer PO Number
PO000007202

Item No.
Description

Customer No. CDART100
Ship Via Pick-Up

Sales Rep. Barney Bangs
Packing Slip No. 30330

Qty	UOM	Qty Shipped/Returned	Qty Backordered
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8421-106
Dart Blade Fold Kit - Pad #7/
Drawing No: (Ref B67-43001-69 Rev B1)
DWG Rev: A
Comments:
Lot No: BATCH0000000003 Qty: 10

10	EA	10	
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8421-105
Dart Blade Fold Kit - Pad #6/
Drawing No: (Ref B67-43001-73 Rev B1)
DWG Rev: A
Comments:
Lot No: BATCH0000000003 Qty: 10

10	EA	10	
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8421-101
Dart Blade Fold Kit - Pad #2/
Drawing No: (Ref B67-43001-83 Rev B1)
DWG Rev: NR
Comments:
Lot No: BATCH0000000003 Qty: 20

20	EA	20	
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8421-102
Dart Blade Fold Kit - Pad #3/
Drawing No: (Ref B67-43001-85 Rev B1)
DWG Rev: NR
Comments:
Lot No: BATCH0000000004 Qty: 12

12	EA	12	
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50810107

RELEASE NOTE

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID : CATULSAF1123HAW
www.tulmar.com
email: info@tulmar.com

Release Note No.

R92-30330

Ship Date

3-Oct-08

Bill No:

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Ship To:

Dart Aerospace
1270 Aberdeen Street
Main Finished Goods Location
Buyer=Chantal Lavoie 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

This release note is a Certificate of Conformance and I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this release note is on file, and can be made available upon request.



Authorized Inspector

10/03/2008

Date



J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

October 20, 2006

Fax To: Tulmar Safety Systems

Fax: 613-632-2030

Attention: Sandra Nadeau

Fax From: Deanna Penner

**EDMONTON
HEAD OFFICE**
12122-68 Street
Edmonton AB T5B 1R1
Canada
Phone: (780) 474-5721

Certificate of Conformance

Re: PO 11878 for Oxford 7 Black

The goods shipped on P/O 11878 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating (approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.))

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Manufacture Date: 1) 50 yds each 9/11/06 Piece # 101629822, 101629830, 101629848, 101630226, 101630234, 101630275 & 101630283 &
2) 50 yds each 10/12/06 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

Lot Number: 1) 50 yds each, #217079 Piece # 101629822, 101629830, 101629848, 101630226, 101630234, 101630275 & 101630283
2) 50 yds each, #221709 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

Sincerely;

J. Ennis Fabrics Ltd.

D. Penner

Deanna Penner
Product Development

English: 1-800-66-ENNIS

Fax: (780) 479-6135
www.jennisfabrics.com

Français: 1-888-66-ENNIS

used For: B-67-43001-69

-73
-83
-85

TEL # 1495/10

CALGARY
2nd Floor 337-17 Avenue SW
Calgary AB T2S 0A5
Canada

VANCOUVER
13811 Bridgeport Road
Richmond BC V6V 1J6
Canada

